



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5638-1

Job Sheet 203102



Part No: D5638-1

Job Qty: 8 pcs

Part Name: Saddle, Outboard, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/8/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/25/19

Description:

Type: Stock

Note: DWG D5638 REV.A IPP REV.A NEW ISSUE 19/02/06 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	8 pcs	11/25/19		0.00	0.00	HAAS - 1		
							HAAS - 2		
							HAAS - 3		SBL 19/11/25
							HAAS - 4		
110	HAAS 4 Axis - B4B	8 pcs	11/25/19		3.00	8.89	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL/VH 19/11/27
							HAAS - 4 - B4B		
120	QC 2	8 pcs	11/25/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S234463



Part: D5638 - 1

Job No: 203102

Serial No/Batch: S234463

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 11/25/19

11/8/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
130 QC 8	8	11/25/19	0.00 0.00	QC 8 - 12	
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
140 Handfinish - 1-1 Chemical-B4B	8	11/25/19	0.00 1.00	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 -	

mmL 19/11/30

★ DEC 02 2019

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				B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	8 pcs	11/25/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	DAS 41 DEC 05 2019
				QC 7 - 47	8-89
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
152 Spray Paint - 2 - B4B	8 pcs	11/25/19	0.00 4.00	Spray Paint - 1 - B4B	DAS 41 DEC 05 2019
				Spray Paint - 2 - B4B	8-89
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
154 QC 14	8 pcs	11/25/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	

		QC 14 - 43	
		QC 14 - 24	
		QC 14 - 61	
		QC 14 - 81	DEC 27 2019
160 Packaging 3-1 - Stock - B4B	8 pcs	11/25/19	0.00 0.00
Oscar DEC 27 2019		Packaging 3 - 1 - B4B	
		Packaging 3 - 2 - B4B	
		Packaging 3 - 3 - B4B	✓ ST392 ✓
		Packaging 3 - 4 - B4B	
		Packaging 3 - 5 - B4B	
		Packaging 3 - 6 - B4B	
		Packaging 3 - 7 - B4B	
		Packaging 3 - 8 - B4B	
		Packaging 3 - 9 - B4B	
		Packaging 3 - 10 - B4B	
		Packaging 3 - 11 - B4B	
		Packaging 3 - 12 - B4B	
		Packaging 3 - 13 - B4B	
		Packaging 3 - 14 - B4B	
		Packaging 3 - 15 - B4B	
		Packaging 3 - 16 - B4B	
		Packaging 3 - 17 - B4B	
		Packaging 3 - 18 - B4B	
		Packaging 3 - 19 - B4B	
		Packaging 3 - 20 - B4B	
		Packaging 3 - 21 - B4B	
		Packaging 3 - 22 - B4B	
		Packaging 3 - 23 - B4B	
		Packaging 3 - 24 - B4B	
		Packaging 3 - 25 - B4B	
		Packaging 3 - 26 - B4B	
		Packaging 3 - 27 - B4B	
		Packaging 3 - 28 - B4B	
		Packaging 3 - 29 - B4B	
		Packaging 3 - 30 - B4B	
		Packaging 3 - 31 - B4B	
		Packaging 3 - 32 - B4B	
		Packaging 3 - 33 - B4B	
		Packaging 3 - 34 - B4B	
		Packaging 3 - 35 - B4B	
		Packaging 3 - 36 - B4B	
170 QC 21 - SA	8 pcs	11/25/19	0.00 0.00
		QC 21 - SA - 21	✓ ST392 ✓
		QC 21 - SA - 70	DAS
		QC 21 - SA - 53	21 DEC 27 2019
Part Op 110 - 1-Machine per folio FC510 DWG REV: <u>AF</u> FOLIO REV: <u>AF</u> 2- Deburr and break all sharp edges Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 152 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: <u>52B188</u> PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: <u>5210653</u> 154 - (QC14- Inspect Spray Paint) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)			
Job BOM			
Part / Item	Component Name	Quantity	Operation
D6101-003	Saddle Billet, 7075	8 pcs (1 ea)	100-Machining - Issue SN
Container			

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Machining - Issue SN	D6101-003	8	70	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order: 203102
Description: SADDLE, OUT BOARD, L.H.		Part Number: D5638-1
Inspection Dwg: D5638 Rev: A DSK: Rev:		Page 1 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.256	0.263		0.258	0.258	0.258	0.258	0.258
B	0.110	0.130		0.120	0.120	0.120	0.120	0.125
C	0.35	0.41		0.375	0.375	0.375	0.375	0.375
D	0.110	0.130		0.122	0.125	0.120	0.120	0.120
E	1.870	1.880		1.875	1.875	1.875	1.875	1.875
F	1.870	1.880		1.875	1.875	1.875	1.875	1.875
G	0.635	0.645		0.648	0.639	0.638	0.638	0.638
H	1.395	1.405		1.400	1.400	1.400	1.400	1.400
I	1.395	1.405		1.400	1.400	1.400	1.400	1.400
J	0.241	0.261		0.248	0.250	0.251	0.250	0.250
K	0.02 x 45°	0.08 x 45°		0.050	0.050	0.050	0.050	0.045
L	1.565	1.575		1.575	1.575	1.575	1.575	1.575
M	0.490	0.510		0.500	0.503	0.500	0.500	0.502
N	0.213	0.233		0.221	0.225	0.220	0.220	0.220
O	0.113	0.133		0.121	0.120	0.120	0.120	0.120
P	0.110	0.130		0.120	0.120	0.120	0.120	0.121
Q	0.675	0.695		0.682	0.680	0.680	0.680	0.680
R	1.125	1.145		1.135	1.135	1.135	1.135	1.135
S	1.346	1.366		1.354	1.355	1.355	1.355	1.355
T	5.990	6.010		5.999	6.001	5.998	5.998	6.000
U	1.090	1.100		1.102	1.103	1.100	1.100	1.100
V	0.990	1.010		0.999	0.998	0.998	0.998	0.998
W	0.490	0.510		0.501	0.503	0.500	0.500	0.503
X	1.245	1.255		1.250	1.250	1.250	1.250	1.250
Y	2.495	2.505		2.500	2.500	2.500	2.500	2.500
Z	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AA	0.313	0.318		0.313	0.313	0.313	0.313	0.313
AB	0.510	0.515		0.512	0.511	0.510	0.510	0.510
AC	0.235	0.240		0.236	0.237	0.237	0.238	0.238
AD	0.02 x 45°	0.08 x 45°		0.048 x 45°	0.049	0.050	0.050	0.050
AE	0.115	0.135		0.127	0.126	0.125	0.125	0.125
AF	0.110	0.130		0.119	0.120	0.118	0.118	0.121
AG								
AH								

Accept/Reject

Measured by: SBC	Date: 19/11/26
Audited by: [Signature]	Date: 19/11/30
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

DART AEROSPACE LTD		Work Order: 203102
Description: SADDLE, OUT BOARD, LH		Part Number: D5638-1
Inspection Dwg: D5638 Rev: A	DSK:	Rev:
		Page 2 of 2

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1 6	2 7	3 8	4	5
A	0.256	0.263		0.258	0.258	0.258		
B	.110	.130		0.125	0.125	0.125		
C	0.35	R .41		0.375	0.375	0.375		
D	.110	.130		0.125	0.125	0.125		
E	1.870	1.880		1.875	1.875	1.875		
F	1.870	1.880		1.875	1.875	1.875		
G	.635	.645		0.639	0.639	0.639		
H	1.395	1.405		1.400	1.400	1.400		
I	1.395	1.405		1.400	1.400	1.400		
J	.241	.261		0.251	0.250	0.250		
K	.02 x .45°	.08 x .45°		0.048	0.046	0.048		
L	1.565	1.575		1.575	1.575	1.575		
M	.490	.510		0.501	0.501	0.502		
N	.213	.233		0.222	0.222	0.221		
O	.113	.223		0.125	0.121	0.121		
P	.110	.130		0.121	0.126	0.120		
Q	.675	.695		0.685	0.685	0.685		
R	1.125	1.145		1.135	1.135	1.135		
S	1.346	1.366		1.354	1.353	1.355		
T	5.990	6.010		6.003	6.003	6.002		
U	1.090	1.100		1.100	1.100	1.100		
V	.990	1.010		0.999	0.998	0.998		
W	.490	.510		0.503	0.507	0.503		
X	1.245	1.255		1.2500	1.2500	1.250		
Y	2.495	2.505		2.500	2.500	2.500		
Z	1.245	1.255		1.2500	1.2500	1.2500		
AA	0.313	0.318		0.313	0.313	0.313		
AB	.510	.515		0.511	0.511	0.511		
AC	.235	.240		0.2375	0.237	0.2375		
AD	.02 x .45°	.08 x .45°		0.05 x .45	0.050	0.050		
AE	.115	.135		0.126	0.125	0.124		
AF	.110	.130		0.120	0.119	0.119		
AG								
AH								

Accept/Reject

Measured by: <i>[Signature]</i>	Date: 19/11/22
Audited by: <i>[Signature]</i>	Date: 19/11/20
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐		Cross tube ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐		Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐		Engineering ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐		MRB (QS1042) ☐ ☐ ☐ ☐ ☐																											
Date : _____		Sequence #: _____		QTY Affected : _____		Disposition																																	
Description Work Order Deviation				Completed By																																			
				Lead hand / Supervisor																																			
				QC / QA Coordinator																																			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details:								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong																																				
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